



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001
Job Sheet 186707



Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/4/19	1/4/19	0.00	0.00	Start Up Stores/Pkg-1		NOV 28 2018
110	Packaging	1 pcs	1/4/19	1/4/19	0.00	0.00	Packaging1-1		9-89 DAS 69
120	QC	1 pcs	1/4/19	1/4/19	0.00	0.00	QC4	DEC 22 2018	9-89 DAS 69
130	Packaging	1 pcs	1/4/19	1/4/19	0.00	0.00	Packaging3-1	DEC 22 2018	9-89 DAS 69
135	DC	1 pcs	1/4/19	1/4/19	0.00	0.00	DC	DEC 27 2018	DAS 70
140	QC21-FG	1 Ea	1/4/19	1/4/19	0.00	0.00	QC21	DEC 27 2018	9-89

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5136925
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5136931
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5123708
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	506695x2 5119441x2
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5119256
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5117182
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	3091495
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5119224
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5081641
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5063686
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5092525
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5049669
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5063766
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5038797
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5050332
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	3038824
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5082442
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5063780
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5038801
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5044802

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐					
Date : _____		Sten #: _____		MRB (QSI042) Approval			
Descripti Dart Aerospace Ltd. 1270 Aberdeen Street Lakeshore, ON K6L 1K7 CANADA TEL: 1 613 662-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S137078 Part: 646.4001 Job No: 186707 Serial No/Batch: S137078 Revision: _____ Inspector: _____ Exp Date: 05/11/2019 Instructions: FAA STC SR02180LA 14/88/07, T6aSTC SH09 -							
Root Cause <table border="0" style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verificati ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>				Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verificati ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	ge ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
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OTHER : _____							

J08186707

(006698)

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646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation	5063754
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5118787
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5070843
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5131076
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5073258
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5124377
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5641250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5128109
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5041498
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5056998
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5097197
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5128124
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5122789
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5130322
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095479
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5098032
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5131193
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5112901
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5119258
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5080637
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5104032X1 5127332X1
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5131214
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5103962
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5108575
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	5153848
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	FM134063
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	5124089
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	5123425
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5100409
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5094592
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5109736
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	3103943
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5118346
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	3099526
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5071834
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	51241664
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	3104364
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5131198X15 FM134134X7
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5094554
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5104011
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5131201
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5075330
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5123456
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5107196

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	192	0
	600.0990	1	4	0
	600.0991	1	4	0
	600.1012	1	17	0
	600.1013	5	47	0
	646.2910	1	20	0
	646.3001	1	14	0
	646.3110	1	7	0
	646.3210	1	12	0
	646.3301	1	7	0
	646.3510	1	37	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

646.3511	1	37	0
646.3610	1	17	0
646.3710	1	46	0
646.3711	1	39	0
646.3712	1	35	0
646.3713	1	25	0
646.3714	1	19	0
646.3715	2	25	0
646.3716	1	33	0
646.3717	1	22	0
646.3718	2	30	0
646.3719	2	28	0
646.3810	2	15	0
646.3811	1	24	0
646.3812	2	8	0
646.3813	1	9	0
646.3910	4	91	0
646.3911	1	16	0
646.3912	4	89	0
646.3913	1	32	0
646.9410	1	94	0
647.0112	2	54	0
647.7703	2	22	0
650.9201	2	23	0
AN3-11A	10	85	0
AN3-12A	2	82	0
AN3-13A	1	92	0
AN3-3A	4	164	0
AN3-4A	10	314	0
AN3-5A	2	296	0
AN3-6A	2	170	0
AN316C4R	2	21	0
AN44-5A	2	27	0
AN4C7A	2	127	0
AN665-34R	2	33	0
CCR264SS3-02	36	519	0
CR3213-5-3	14	216	0
MS20426AD5-7	2	980	0
MS20470AD5-5.5	8	218	0
MS20470AD5-6	8	1,001	0
MS20470AD5-7	3	134	0
MS21042L08	2	1,084	0
MS21042L3	63	1,662	0
MS21042L4	2	1,872	0
MS21047-3	18	400	0
MS24693-C278	5	119	0
MS24694-S51	5	275	0
MS24694-S54	2	392	0
MS24694-S55	3	86	0
MS27039-08-13	2	554	0
MS27039-1-10	2	243	0
MS27039-1-12	6	220	0
MS27039-1-16	24	473	0
MS27039-1-19	22	226	0
MS27039-1-20	2	91	0
MS27039-1-21	4	94	0
NAS1149F0332P	144	1,017	0
NAS1149F0363P	2	543	0
NAS1149F0432P	4	678	0
NAS1149FN832P	4	1,511	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

REFERENCE ONLY

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NOTES:

▲ AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

A  3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

B  NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(s)

0.5304

	5		5	3	7B	601.3875	SCREW		MS2042-08
	1		1	4	77	646.9410	SHIM		
			4	76	601.2764		WASHER		NAS1149FNB32P
			2	2	75	601.2973	LOCKNUT		MS21042-08
			2	2	74	601.2988	SCREW		MS27039-0813
			2	2	73	601.2943	LOCKNUT		MS21042-5
			2	2	72	601.3128	NUT		AN316C4R
			2	2	71	601.3209	LOCKNUT		MS21042L4
			4	4	70	601.2638	WASHER		NAS1149F04S20P
			2	2	69	601.2669	BOLT		AN4C7A
			2	2	68	601.3119	CLEVIS		A1665-34R
			2	2	67	601.3121	EYE BOLT		A1444-5A
			2	2	66	650.9201	EYE BRACKET ASSY		
REF	REF			REF	65	647.5701	GPS MOUNT KIT		
				2	64	601.3151	WASHER		NAS1149F03A39P
					63	601.2911	SCREW		MS24615CS3
			24	24	62	601.2637	SCREW		MS27039-1-16
2			2	2	61	601.2763	BOLT		AN3-12A
			1	1	60	646.3913	SHIM		
			4	4	59	646.3912	SHIM		
			1	1	58	646.3911	SHIM		
			4	4	57	646.3910	SHIM		
			5	5	56	600.1013	PRIMER		
			8 FT	8 FT	55	600.0129	VHB TAPE		
			1	1	54	600.1012	SEALANT		PR-145 CLASS B
			1	1	53	600.0991	MAGNABOND 6396 PART B		
			1	1	52	600.0990	MAGNABOND 6396 PART A		
6			10	10	51	601.2826	BOLT		AN3-11A
				2	50	646.3814	WIPER BRACKET		
				2	49	601.2910	SCREW		MS27039-1-18
			2	2	48	601.1365	SCREW		MS27039-1-10
			2	2	47	646.3719	DOUBLER		
			2	2	46	646.3718	CUSTOM WASHER		
			1	1	45	646.3717	DOUBLER		
			22	22	44	601.1948	SCREW		MS27039-1-19
			2	2	43	601.1952	SCREW		MS27039-1-20
			4	4	42	601.1956	SCREW		MS27039-1-21
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	SPEC.

[illegible]

REFERENCE ONLY

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